

Work Order ID 70099

Thursday, May 26, 2011 3:08:35 PM



Page 1

Item ID: D4309-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 5/27/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/2/2011 Req'd Qty: 20.00



Customer:

Reference:

11-05-16

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4309	A								

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FB034 & DWG

FOLIO REV: *11/5/30*

DWG REV: *11/5/30*

2-DEBURR AS REQUIRED

11/5/30

20 *φ*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11/5/30

20 *φ*

120

QC8- Inspect parts - second check

0.00



QC

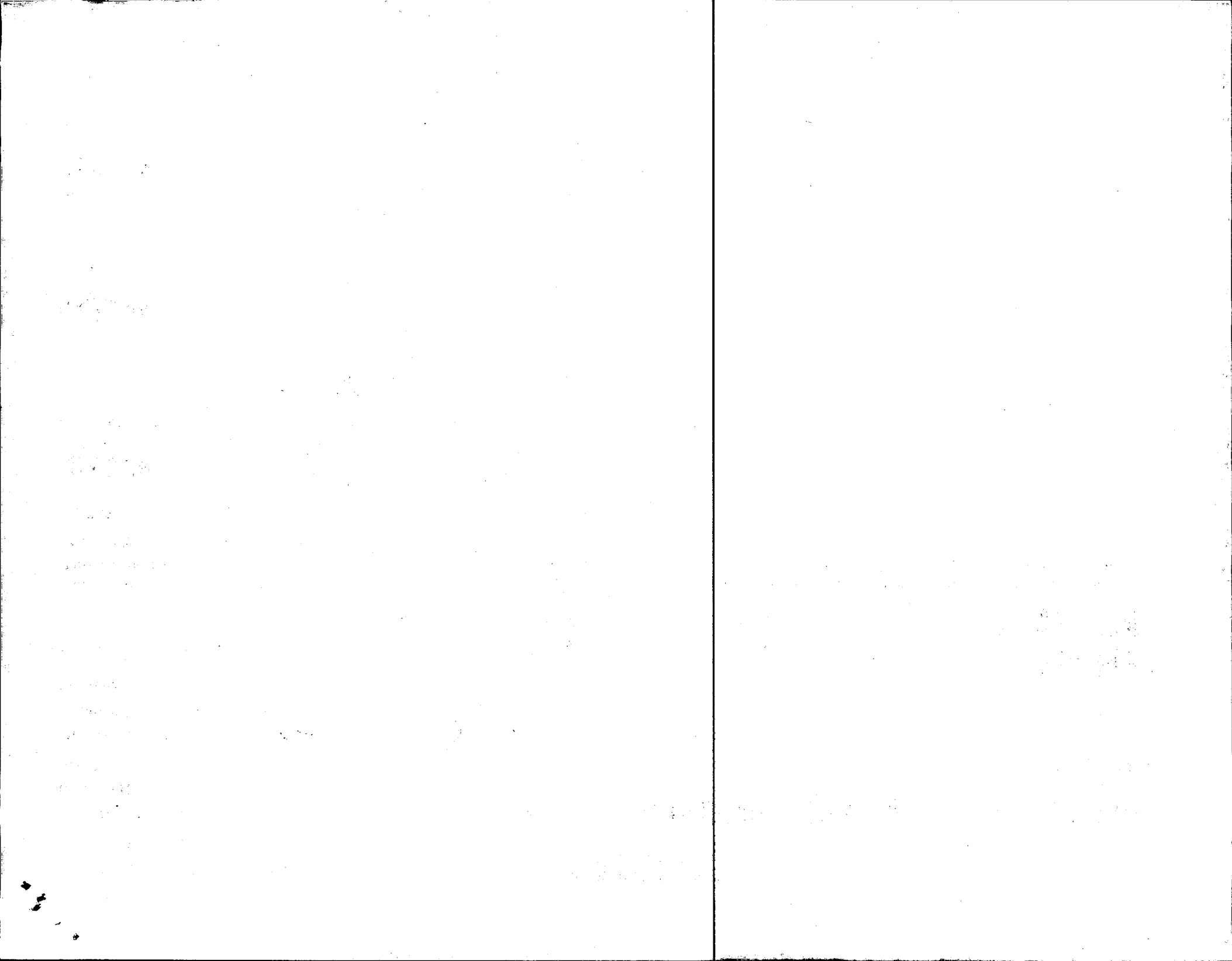
Memo

0.00

Quality Control

11-5-30

20 *φ*



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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 139E

0.00



Packaging

Memo

0.00

Packaging

11/5/30 [Signature] 20

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/31 [Signature]

11-05-31
(20)

Picklist Print

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Page 1

Work Order ID: 70099



Parent Item: D4309-1



Parent Item Name: Bushing


Start Date: 5/27/2011

Required Date: 6/2/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 11-01-11 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500  6061-T6 Round Bar .500"		Purchased	No			100	f	86.7050	0.08333	1.754316			

Location

Loc Qty

Loc Code

MAT012

86.705

114488

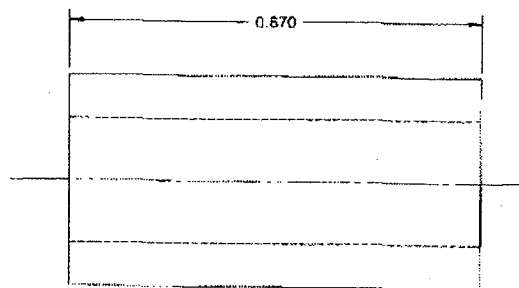
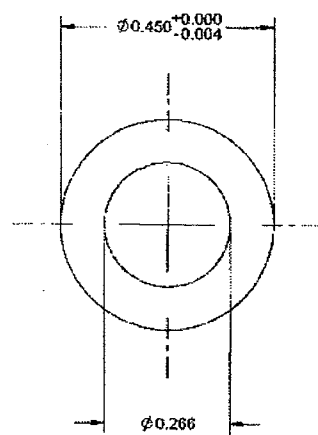
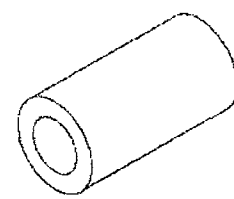
4.605

17379

82.1

Handwritten notes:
11/2/13
1.754316

w/o 70099



D4309-1 BUSHING

RELEASED
2011-05-21

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/B, QQ-A-200/B, ASTM B211, OR ASTM B221
REF DART SPEC. M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.7
- 7) WEIGHT: 0.03 lbs

A		NEW ISSUE		CP	11.01.10
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD			
DRAWN		HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	D4309	REV. A	
MFG. APPR.		TITLE	BUSHING	SCALE	1 OF 1
APPROVED				NTS	
DE APPR.		COPYRIGHT © 2011 BY DART AEROSPACE LTD			
DATE	11.01.10	THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE RELEASED FOR ANY PURPOSE OR FOR ANY OTHER REASON TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.			

